

Work Order ID 145105

Tuesday, May 03, 2016 1:50:46 PM

145105

Page 1

Item ID: D139-1012-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AW139 High Capacity Cargo Net

Start Date: 5/6/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 03 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	DAS							
D139-1012-011	A	10 9-89	DAS 6 9-89					DAS 21 9-89	JUL 28 2016
110	Document Control	0.00		JUL 27 2016					
110									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D139-1012-011 chg 001								
120	Pick Kit	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC4- 100% Inspect kits for completeness	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

JUL 28 2016

DAS
28
9-89

DAS
JUL 28 2016

DAS
27
9-89

JUL 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

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145105

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/6/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/10/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

Accept

Qty

Reject
Qty

Reject Number

**Insp.
Stamp**

140

0.00

140

0.00

Packaging

Memo

Identify and pack for shipping as per PPP D139-1012-011

Location:

PPP Rev:

Sold

DAS
27

JUL 28 2016

150

QC21- Final Inspection - Work Order Release

0.00

150

0.00

QC

Memo

Quality Control

DAS
21
9.50

JUL 28 2016

2m 16/07/28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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145105

D139-1012-011

Required Date: 6/10/2016

Required Qty: 1.00

Comments: IPP REV:A 16.04.27 NEW ISSUE DD VERF:JLM

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
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Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____ _____ _____			
Misidentified ☐		Past Due ☐					

Picklist Print

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Work Order ID: 145105

145105

Parent Item: D139-1012-011

D139-1012-011

Parent Item Name: AW139 High Capacity Cargo Net

Start Date: 5/6/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

AN526-10R12

AN526-1032-R12

AN526-10R12

Screw

AN970-3

AN970-3

Washers

No

Each

0.0000

4

**

m1568

DAS

6

9-89

28

9-89

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST260a

198

m129630

198

ST321

25

m128057

25

Each

163.0000

2

**

135015

DAS

6

9-89

28

9-89

MS21059L3

Purchased

No

MS21059L3

Nut Plate

Location

Loc Qty

Loc Code

CA

8

M129682

8

GA

18

M133990

18

ST301

111

M134055

15

M134257

50

M134509

46

ST303

26

M133016

26

Each

71.0000

7

**

PC

DAS

6

9-89

28

9-89

DAS

28

9-89

MS24665-136

Purchased

No

MS24665-136

Cotter Pins

Location

Loc Qty

Loc Code

ST289

71

2421

71

DAS
27
9-89

7

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Shop Packet Print

Page 2

QA Closed: _____ Date: _____

Work Order update only

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I

4.0 WEIGHT AND BALANCE

The following weight and balance is for the Dart installation. The weight and balance of parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D139-1012-011 CARGO NET INSTALLATION	28.8 lb 13.0 kg	±0.0 in ±0.0 m	±0.0 in lb ±0.0 m kg	280 in 7.11 m	8064 lb in 92.4 kg m

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D139-1012-011	CARGO NET INSTALLATION
1	D139-1012-041	CARGO NET ASSY
7	D5320-043	D-RING ASSEMBLY
4	D5339-1	CARABINER CLIP
4	D5397-1	D-RING
1	D5408-1	SUSPENSION ROPE
2	D5409-1	PLACARD
2	D5409-3	PLACARD
4	AN526-10R12	SCREW
4	AN970-3	WASHER
2	MS21059L3	NUT PLATE
7	MS24665-136	COTTER PIN